



PROCESS SPECIFICATION

GULF COAST DIVISION
LAKE CHARLES, LOUISIANA

PROCESS SPECIFICATION NO. 4006
CLEANING AND CONDITIONING OF ALUMINUM SURFACES

Prepared By	<i>David K. Murphy</i>	DATE	<i>3/23/87</i>
APPROVALS			
Engineering:	<i>D. J. Gelly</i>		<i>4/17/87</i>
Quality Control:	<i>David K. Murphy</i>		<i>3/23/87</i>
Production:	<i>Robert Pinner</i>		<i>3/23/87</i>

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1. SCOPE

This specification establishes the requirements and procedures for cleaning and conditioning aluminum surfaces.

2. MATERIALS

Alumi prep 33 Amchem Products, Inc.
Stock No. DX533 Ambler, Pa 19002

3. CLEANING PROCEDURE

- 3.1 Prepare cleaning and conditioning chemical per manufacturers instructions.
See Appendix A.

WARNING

Observe manufacturers precautions listed on product.

- 3.2 Brush or spray solution on aluminum, or dip aluminum in solution.
- 3.3 Allow a dwell time of one to three minutes.
- 3.4 Scrub heavily oxidized or corroded areas with a synthetic abrasive pad. Do not allow to dry before rinsing; re-wet with solution if necessary. Do not use steel wool.

4. QUALITY STANDARDS

- 4.1 Rinse well with clean water. The metal surface is clean when water sheets out. If the water beads or channels, repeat cleaning.
- 4.2 Dry article (air dry or oven)
- 4.3 For optimal corrosion resistance and paint adhesion, apply an aluminum conversion coating as soon as practical.

APPENDIX "A"

ALUMIPREP® 33 CLEANING AND CONDITIONING CHEMICAL

ALUMIPREP 33 is a non-flammable acid aluminum cleaner, brightener and conditioner. Do not use on high copper or silicon bearing alloys.

ALUMIPREP 33 penetrates deep into the pores of the aluminum and lifts or dissolves oxidation, soils and other surface contaminants.

ALUMIPREP 33 prepares aluminum for welding.

ALUMIPREP 33 cleaning and conditioning chemical prepares the surface for chrome conversion coating with ALODINE®.

FOR BEST RESULTS: Follow general use instructions. Keep solutions, brushes and rags clean. Prime immediately after drying.

**WARNING! CAUSES IRRITATION.
HARMFUL IF SWALLOWED.**

Avoid contact with eyes, skin, and clothing.

Avoid breathing mist and vapor.

Keep container closed.

Wash thoroughly after handling.

Use with adequate ventilation.

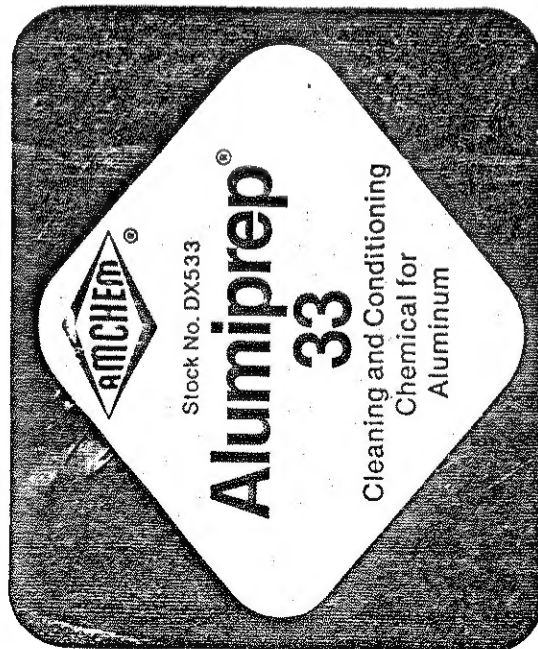
FIRST AID: If swallowed, dilute by giving several glasses of water or milk and induce vomiting by putting finger down throat. Call a physician. IN CASE OF CONTACT, immediately flush eyes or skin with plenty of water for at least 15 minutes. Call a doctor in case of contact with eyes.

AMCHEM PRODUCTS, INC., Ambler, PA 19002
a **flintek** company

GENERAL USE INSTRUCTIONS:

Note: Read precautionary information before using.

1. DILUTE one part ALUMIPREP® 33 cleaning and conditioning chemical with two to three parts water in a plastic container. For clean metal, dilute with four to six parts water.



- Deep Cleans, Brightens, Conditions.
- Removes Oxidation Corrosion.
- Chemically Etches Aluminum Surface.
- Prepares Aluminum for Painting.
- Prepares Aluminum for Welding.

WARNING! KEEP OUT OF REACH OF CHILDREN

Read Side Panel for Precautions
Contains Phosphoric Acid

Contents: 128 Oz.-One U.S. Gallon-3.785 Liters
FOR PROFESSIONAL AND INDUSTRIAL USE ONLY